

Date: Monday, 2/27/2006 4:17:50 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 25968		
Estimate Number	: 10271		
P.O. Number	: N/A	Part Number	: D2561
This Issue	: 2/27/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2561 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25088	Drawing Revision	: B
		Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 3/20/2006
Checked & Approved By	: <u>06.02.28</u>	Qty:	42
Comment	: Est C 00.05.19 Added inspect level 8 EC	Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0250X06000	6061-T6 Bar .25" x 6.0"
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Comment: Qty.: 0.3850 f(s)/Unit Total: 15.4014 f(s)  
 Material: 6061-T6, or 5052-H34 6.00" x 0.25" Thick  
 Batch: M17869 = 139.2 inches

M17037 = 43.5 inches

J.L 06.03.01

21

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 1-Cut blanks: 8.70"  
 Note: 1 blank makes 2 parts

J.L 06.03.01

42

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 1-Machine as per folio D2561  
~~2-Deburr, no sharp edges~~  
sent to cut

J.L 06.03.01 42

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06.03.01 42

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: DS Date: 06/03/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 25968

Part Number: D2561

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*ml 06/03/01*

*42*

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr , no sharp edges

*SB 06/03/08*

*42*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA*

*SB 06/03/08*

*42*

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*PD 06/03/09* *(42)*

Job Completion



*u 06/03/09*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

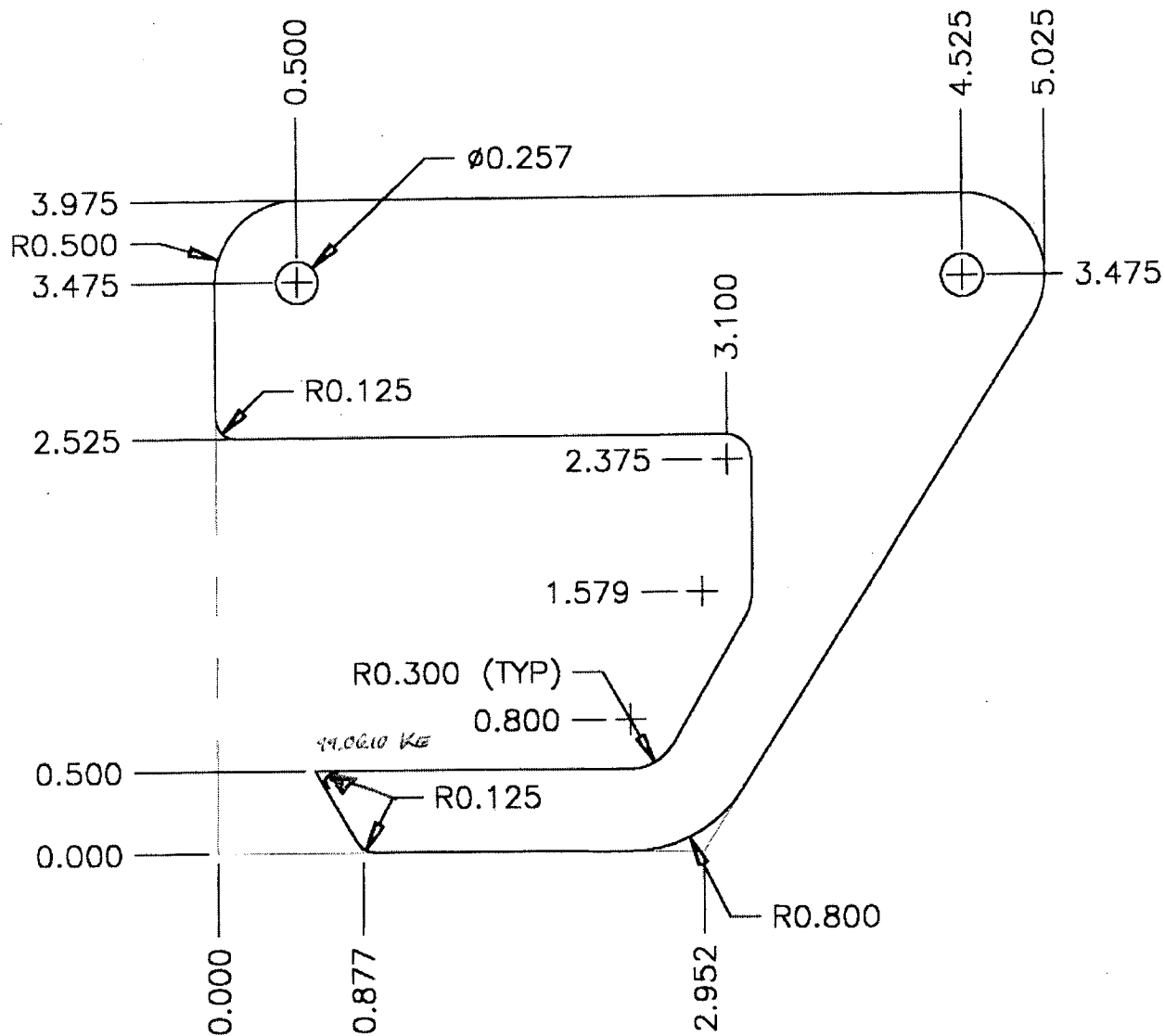
**NOTE:** Date & initial all entries





DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2561	REV. B SHEET 1 OF 1
DATE 96.04.26		TITLE LUG PLATE	SCALE 1:1

RELEASED  
96 05 06



MATERIAL: 6061-T6 0.25 THICK  
OR 6063-T6 0.25 THICK  
OR 5052-H34 0.25 THICK

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25968